

• Work Order ID 63532



Page 1

November 3, 2010 3:28:00 PM

Item ID: K358-044-001

Accept



Setup Start



Revision ID:

Item Name: Reservoir Bottle L62W-001

Stop



Start Date: 11/03/10 Start Qty: 2.00



Cust Item ID:

Required Date: 12/03/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: CL

Date: 10/11/04 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
N/A	Rev N/A

100



PURCHASING

Purchasing

Memo

0.00

CL 10/11/04 2

Purchasing

Issue P/O: 12864 to Luxfer
P/N: L62W-001 Hoop Wrapped Cylinder
6.89" O.D x 20.75" long
Volume = 549 cu inWeight = 16.5 lbsService Pressure = 3000 psi
Thread size = 1.125-12 UNF
Certificate of conformity is required

110



Receive & Inspect for Damage & Mat'l Certs

0.00

Ledger 2

Packaging

Memo

0.00

Packaging

Receive & Inspect For Transit Damage Ensure certificate of confromity is attached

115

AC 6



Soln/16

(x2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63532

Page 2

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Cust Item ID:

Required Date: 12/03/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

114



Spray Painting per QSI005 4.2

0.00

Mdl 10 11 18 (2)
(PP)

SprayPaint

Memo

0.00

PRIME AND PAINT AS PER DWG

116



QC14- Inspect Spray Paint

0.00

S 10/11/23

(8)

10 - 11 - 19 (2)

QC

Memo

0.00

120



Identify as per dwg & Stock Location: _____

0.00

Packaging

Memo

0.00

10/11/23 J (2)

Packaging

		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10-11-17	114	<p>scruff outside surface of bottle</p> <p>mask off label (be sure not to use a knife to cut tape)</p> <p>scruff outside surface of bottle using red scotch brite</p> <p>Prime using 4500-C-15/234 primer + 4500-PB154/234-BG catalyst</p> <p>Paint using Imron 555U white w/ U-1925 activator</p> <p>prep surface prior to painting using solvent</p>	/	10/11/18	(2)	10-11-17	10-11-17
						10-11-17	10-11-17

Part No: K358-044-001 PAR #: Fault Category: Finishing NCR: Yes No DQA: Date: 10-11-23

Resolution: rework Disposition: re-work QA: N/C Closed: Date: 10-11-23

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/11/19	116	When removing aluminum plug used to hang bottle for paint, plug stripped leaving some thread inside the threads off bottle. R.C process	/	<ul style="list-style-type: none"> - Run a tap or thread cleaner through bottle. - ENSURE absolutely NO foreign objects in the cylinder. 	/ 10/11/22	S 10/11/23	/	/
			/	<ul style="list-style-type: none"> - Test fit with ass'y fitting to be sure threads will assemble 	/ 10/11/22	S 10/11/23	/	/
						test fit AS21926-312 in each can to ensure fit is the same		

NOTE: Date & initial all entries

Work Order ID 63532

Page 3

November 3, 2010 3:28:00 PM

Item ID: K358-044-001

Accept



Setup

Start



Revision ID:

Item Name: Reservoir Bottle L62W-001

Stop



Start Date: 11/03/10 Start Qty: 2.00



Cust Item ID:

Required Date: 12/03/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/11/23
CL 10/11/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 3, 2010 3:27:59 PM

Page 1

Work Order ID: 63532



Parent Item: K358-044-001



Parent Item Name: Reservoir Bottle L62W-001

Start Date: 11/03/10

Required Date: 12/03/10

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A□03.09.11□New issue□KJ/DS□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
K358-044-001P		Purchased		No		110	Each	0.0000	1	2		11/03/12	(2)

Reservoir Bottle L62W-001

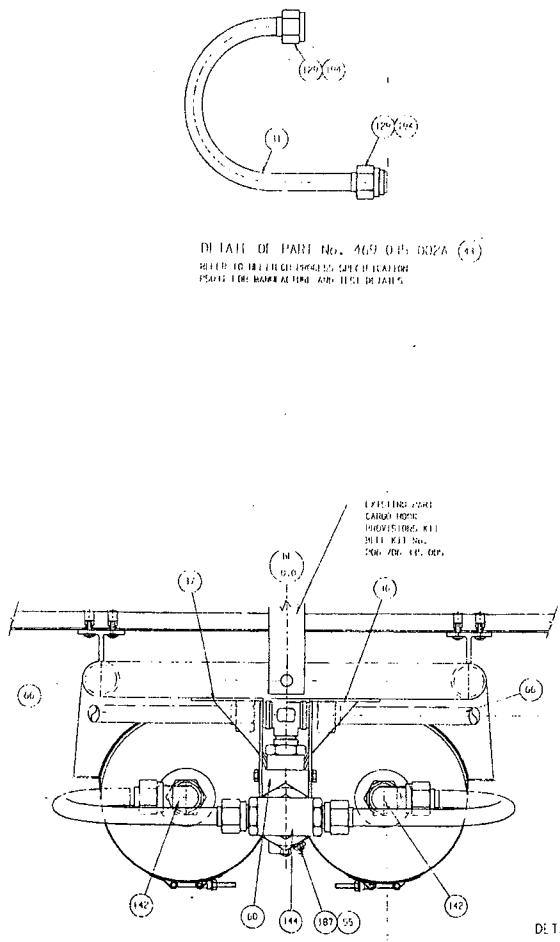
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

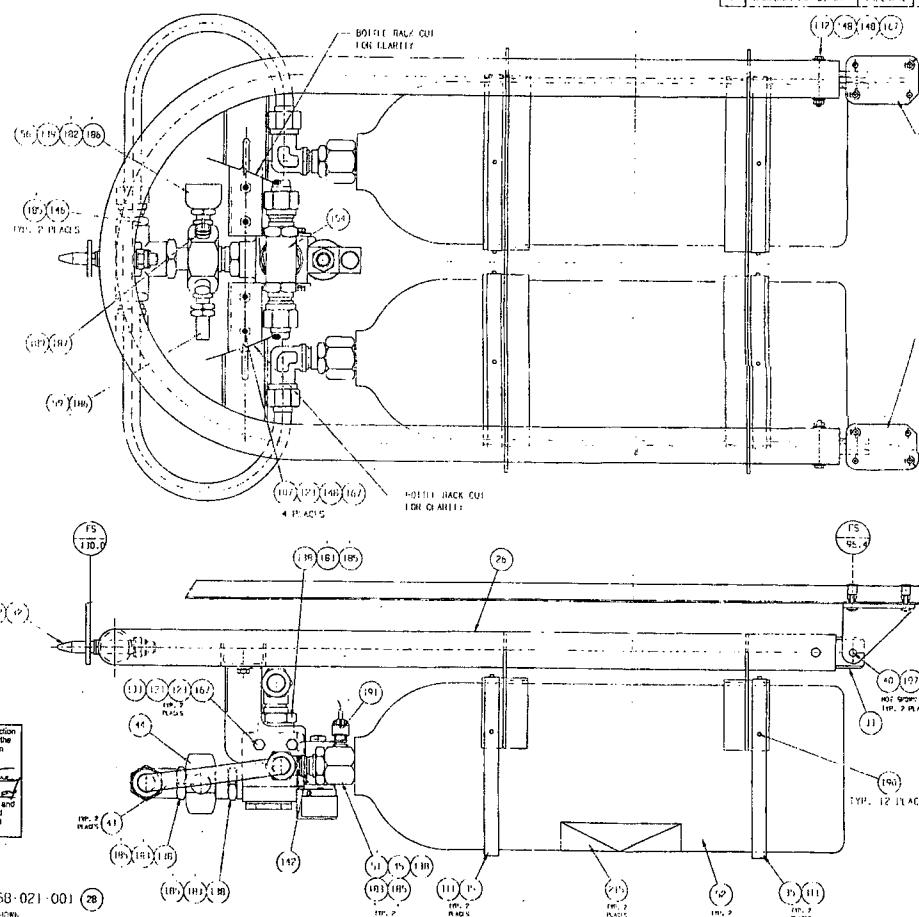
NOTE: Date & initial all entries



DETAIL OF PART No. 469-015-002A (4)
REF ID: B1110015994055 SPECIFICATION
PART FOR BANKING AND TIESE DETAILS

APPROVED pursuant to a direction Given by Regulation 51 ^a of the Civil Aviation Regulations on Date: 15-4-98 Signature: <u>P.W. Webster</u>	
Name: <u>Hallachy Pty Ltd</u> ^b Authorised Person for and on behalf of Hallachy Pty Ltd Certificate of Approval 3300 A.C.N. 012 563 887	

DETAIL OF PART No. 358-021-001 (28)
NOTE: THE INDIVIDUALS NAME AND ADDRESS



(140) (167) 100% PLATES,
DRILL 174" DRILL 1
TEAM AND CEEVIS
ON ASSEMBLY

EXISTING PAINT
CARDED BOOK
PROVISIONS KIT
BILL KIT No.
206 700-195-000

- EXISTING PART
CARDO HORN
PROVISIONS KIT
10 FT. RUE NO.
206 706 375 605

REFERENCE DRAWINGS		MANUFACTURING OPERATIONS		MATERIAL	DIMENSIONS IN INCHES (mm)		 Helitech Pty Ltd <small>PHYSICAL PROPERTY</small> HELITECH HELICOIL LAWNTON AVE, EAGLESFIELD INCORPORATED IN QUEENSLAND AS 1100 <small>PHOTOGRAPH BY</small> Helitech Pty Ltd <small>REASON FOR CHANGES</small> HELICOIL ALL REVISIONS ARE APPROVED BY THE DESIGNER AND APPROVED BY THE MANUFACTURER ON AT LEAST ONE SIDE OF CO.	DRILLS	NORA KINNUNEN	Client	HELITECH PTY. LTD.		
DRAWING NO. OR ID	WATERMARK	ALUMINUM 1000	STAINLESS STEEL	SHIPS TO: HELICOIL HEADING AT HOLE DEEDED HOLE FOR DRILLED HOLES	BRASS	DATE		15/04/98	Title	KWIK FLOAT INSTALLATION CENTRE BOTTLE RACK INSTALLATION DETAIL BELL 206 A & B SERIES			
BILL OF MATERIALS				BRASS		SCALE	1:2.5						
MATERIALS LIST (CONTINUED)						CHECKED BY	C.W. WHITNEY						
						DATE PLOTTED	15/04/98						
						dra	332	cl	117	Drawing Number	BHA/DRA/358-07-01		
						revised				Revision	F		
1	2	3	4	5	6	7	8	9	10	11	12		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO12866

Purchase Order Date 11/04/10
PO Print Date 11/04/10

Page Number 1 of 1

Order From : VU-LUX001

LUXFER GAS CYLINDERS
3016 KANSAS AVENUE
RIVERSIDE, CA 92507
US

Contact Name	Buyer	Chantal Lavoie
Vendor Phone	Requisition Nbr	
Vendor Fax	Tax Resale Nbr	10127-2607
Vendor Account Nbr	Terms	Net 30
	Currency	USD
	FOB	Destination-Collect

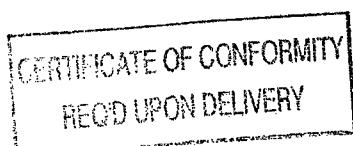
Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED
Col/11/09

Line Nbr	Reference Revision ID	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
Vendor Part Number							
1	K358-044-001P	Reservoir Bottle L62W-001	12/03/10 Yes	2.00 Each	FedEx PI ppd	\$225.0000	\$450.00

Special Inst: LUXFER P/N: L62W-001 HOOP
WRAPPED CYLINDER
6.89" O.D X 20.75" LONG
VOLUME = 549 CU IN WEIGHT = 16.5
LBS SERVICE PRESSURE
= 3000 PSI THREAD SIZE = 1.125-12UNF
B63532

PO Total: \$450.00



No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 1

Change Date: 11/04/10



Luxfer Gas Cylinders

A Division of **Luxfer Inc.**

3016 Kansas Avenue • Riverside • CA 92507
Telephone (951) 684-5110 • Fax (951) 328-1117
www.luxfercylinders.com



PACKING LIST

Shipping Address

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY ON K6A 1K7
CANADA

Information

Document No.	80192758	
Document Date	11/12/2010	
PO No.	PO12866	
PO Date	11/08/2010	
Sales Order No./Date	103032	11/08/2010
Customer No.	3464	
Shipping Conditions	Standard	
Terms of Delivery	FOB LUXFER PLANT, PREPAY AND ADD	
Gross Weight	35.140	LB
Net Weight	29.800	LB
Volumes	1.700	FT3

1 of 1

Shipping Details

Item	Material Description	Storage Location	Quantity	Weight
0010	<p>** CERTIFICATE OF CONFORMITY UPON RECEIPT **</p> <p>L62W-001 CYLINDER, ALUMINUM FIBERWRAPPED, 62 CF</p> <p>Plant : 62 BASE MODEL L62W SERVICE PRESSURE 4500 PSI SURFACE FINISH HOOPWRAPPED WITH FIBERGLASS THREAD 1.125-12 UNF 2B, STD GLAND INTERNAL FINISH THERMO CLEANED LABEL CUSTOM LABEL APPLIED APPROVING AUTHORITY DOT/TC - USA DOT/TRANS CANADA</p>	1	2 EA	35.140 LB



Luxfer® Gas Cylinders Composite Cylinder Division

CERTIFICATE OF CONFORMANCE

CUSTOMER: DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY ON K6A 1K7
CANADA

DATE: 11/10/2010

CUSTOMER P.O. NO.: PO12866

LUXFER S.O. NO.: 103032

CUSTOMER DRAWING NO.: N/C

S
10/10/16

REV. NO.: N/C

ITEM	LUXFER PART NO.	REV	SAMPLE PLAN	DESCRIPTION	QUANTITY
1	L62W-001	E	N/A	COMPOSITE CYLINDERS 549 CU. IN. / 3000 PSI	(2)

PREFIX:	WS
SERIAL NUMBERS:	5332,5336

We hereby certify that all materials of construction, processes of manufacture, required inspections and tests meet all applicable specification requirements. Material certifications, inspection and test results are available for review. We also certify that the above listed product items satisfactorily meet all purchase order, drawing and specification requirements for the revisions identified except for the following:

EXCEPTIONS:	None.
--------------------	-------

NAME: Robert Felix

SIGNATURE: _____

TITLE: Shipping Coordinator

DATE: 11/10/2010

3016 Kansas Ave.
Riverside, CA 92507
USA
Tel: (909)-684-5110
Fax: (909) 341 9223

Setting the Standard Worldwide®